



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2805-2**Job Sheet 190376****Part No:** D2805-2**Job Qty:** 20 pcs**Part Name:** Stop**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/7/19**Job Tracking No:****Due Date:** 3/5/19**Created By:** Marie Lajeunesse**Type:** SOLD *STH***Description:****Note:** DWG REV B IPP: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		3/5/19	0.00	0.26	Bandsaw - 1		<i>DJP 19-02-28</i>
110	HAAS 4 Axis - B4B	20 pcs		3/5/19	0.16	6.49	HAAS - 1 - B4B		<i>DJP 19-02-28</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs		3/5/19	0.00	0.00	QC 8 - 12		<i>20X 19/03/16</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 47		
140	Handfinish - 1-1 Chemical-B4B	20 pcs		3/5/19	0.00	0.77	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		

**Container No:** S157197**Part:** D2805-2**Job No:** 190376**Serial No/Batch:** S157197**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 02/27/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/03/19
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 3	20 pcs	3/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
160 Packaging 3-1 - Stock - B4B	20 pcs	3/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
170 QC 21 - SA	20 pcs	3/5/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-89

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QC 21 - SA - 53

Part Op 100 - (Bandsaw) Cut Bar: 3.150" Long +0.010/-0.030"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Machine as per Folio FA104 and Dwg D2805 Identify as D2805-2

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____) LOCATION : GA

170 - (QC21- Final Inspection - Work Order Release)

MAT
used
5-328

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X1.500	6061-T6 Bar 1.50 X 1.50	5.2500 ft (.2625 ea)	100-Bandsaw - 1	5033413

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X1.500	5	26	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stop	2.974inches ± 0.010	2.984 2.964	2.974	
2	Stop	0.240inches ± 0.010	0.250 0.230	0.240	
3	Stop	0.100inches ± 0.010	0.110 0.090	0.100	
4	Stop	1.420inches ± 0.001	1.421 1.419	1.420	
5	Stop	1.125inches ± 0.010	1.135 1.115	1.125	
6	Stop	0.250inches + 0.005 - 0.000	0.255 0.250	0.251	
7	Stop	0.250inches ± 0.010	0.260 0.240	0.250	
8	Stop	1.500inches ± 0.010	1.510 1.490	1.497	
9	Stop	1.000inches ± 0.010	1.010 0.990	1.000	
10	Stop	0.875inches + 0.001 - 0.000	0.876 0.875	0.876	

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0.438 +.001
- 0.000.4385 ~~2.4385~~0.608 +.001
- 0.000

.608

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					